




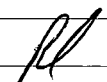




Work Order ID 61670




Tuesday, August 31, 2010 10:45:05 AM

Page 1


Item ID: D3391-025 Accept  Setup Start 
Revision ID: Stop 
Item Name: Aft Tube Assembly
Start Date: 8/31/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 9/7/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan:  Date: 10-8-31 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 


| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3391 | Rev H/ DEO | | | | | | | | |

100  0.00
MORI SEIKI CNC LATHE LARGE
Mori Seiki Memo 0.00
Mori Seiki CNC Lathe Large Turn as per Folio FA599 Rev:  & Dwg D3391 Rev: 
scribe batch # on fwd end at 90 degree


QA 10-09-08 8

110  0.00
QC2- Inspect parts off machine FAI/FAIB
QC Memo 0.00
Quality Control

QA 10-09-08 1

111  0.00
QC8- Inspect parts - second check
QC Memo 0.00
Quality Control

1 1 Pro →


10/11/16

SCRAP

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D 3391-025 PAR #: Fault Category: Skid tubes NCR: Yes No DQA: Date: 10/9/09
 Resolution: SCVAP Disposition: Scrap QA: N/C Closed: Date: 10/12/09

| NCR: 61670 (1) | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------------|------|---|-----------------------------|--|-------------------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 10/9/09 | #100 | Domin Borely Fwd end of Aft tube operator grabbed the wrong tube and ended up Borely Both ends. | 10/09/09 QSI042 | Scrap + Destroy And replace qty x1 M B 56572 | 10/11/06 (signing to Alex) | 10-11-16 | 10/09/09 QSI042 | S 10/09/09 |
| | | R.C. I.O.A. operator wasn't pay attention to what he was grabbing tube he was using. | 10/09/09 KOSU2 | | | | | S 10/09/09 |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 61670

Tuesday, August 31, 2010 10:45:05 AM

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Item ID: D3391-025

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00

Required Date: 9/7/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA 599 Rev: _____ & Dwg D3391 Rev: _____
2-Deburr

130

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

140

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3391-025 PAR #: Fault Category: machined parts NCR: Yes No DQA: Date: 10-12-01
 Resolution: scrap Disposition: scrap QA: N/C Closed: Date: 10/12/02





| NCR: <u>61670(2)</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------------------|------------|--|-----------------------------|--|-----------------|-------------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>10.11.16</u> | <u>120</u> | <u>1.526" WIDE SLOT MACHINED</u> <u>0.275" TOO LONG, QTY(1).</u> <u>P.G. PART NOT ZEROED.</u> <u>R.C LACK OF ATTENTION.</u> | <u>10.11.16</u> | <u>SCRAP PART. NO. REPLACE.</u> <u>7 Side the machining & slot</u> <u>is 0.275" to far up into the</u> <u>tube: Machining is un even</u> <u>from top to bottom</u> | <u>10/11/16</u> | <u>B.A</u> <u>10/12/02</u> | <u>10.11.16</u> | <u>10-12-01</u> |
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NOTE: Date & initial all entries




Work Order ID 61670

Tuesday, August 31, 2010 10:45:05 AM

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Item ID: D3391-025 Accept  Setup Start 
Revision ID: Stop 
Item Name: Aft Tube Assembly
Start Date: 8/31/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 9/7/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150  | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803 | | | | | | | | |
| 160  | BENDING MACHINE - SKIDTUBES | 0.00 | | | | | | | |
| CNC Bend 1 | Memo | 0.00 | | | | | | | |
| CNC Delta 100 Bender | Form as per Dwg D3391 Using Bend Prog 3391025 | | | | | | | | |
| 170  | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

SCRAP

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries


Work Order ID 61670

Tuesday, August 31, 2010 10:45:05 AM

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Item ID: D3391-025 Accept  Setup Start 
Revision ID: Stop 
Item Name: Aft Tube Assembly
Start Date: 8/31/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 9/7/2010 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180  Skidtubes | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| | 1-Open Aft cap pilot hole to .208" as per Dwg D3391 | | | | | | | | |
| | 2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only. | | | | | | | | |
| | 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig. *****Do Not Open To Finished Size***** | | | | | | | | |
| | 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. | | | | | | | | |
| | 5-Open wearplate holes to 0.250" and c'bore as per dwg D3391 | | | | | | | | |
| | 6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391. | | | | | | | | |
| | 7-Deburr | | | | | | | | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 61670

Tuesday, August 31, 2010 10:45:05 AM



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Item ID: D3391-025**Accept****Setup Start****Revision ID:****Stop****Item Name:** Aft Tube Assembly**Start Date:** 8/31/2010 **Start Qty:** 1.00**Cust Item ID:****Required Date:** 9/7/2010 **Req'd Qty:** 1.00**Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop**

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| 200 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | | | | |
| 210 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | | | | |

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 61670

Tuesday, August 31, 2010 10:45:05 AM

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Item ID: D3391-025

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00

Required Date: 9/7/2010 Req'd Qty: 1.00

Cust Item ID:




Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 220  | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | Memo Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: _____ exp. date : _____ cure time 12hrs as per QSI0015 | 0.00 | | | | | | | |
| 230  | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | |
| 235  | Pressure Wash per QSI005 4.3 | 0.00 | | | | | | | |
| HandFinish Hand Finishing | Memo AND REALODINE AS PER PAR09-043 | 0.00 | | | | | | | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 61670

Tuesday, August 31, 2010 10:45:05 AM



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Item ID: D3391-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 240 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ | | | | | | | | |
| 250 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 260 | | 0.00 | | | | | | | |
| | | | | | | | | | |
| HandFinish | HandFinishing | | | | | | | | |
| Hand Finishing | Memo 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 Sikaflex expiry date: _____ | 0.00 | | | | | | | |

SCRAP

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 61670

Tuesday, August 31, 2010 10:45:05 AM

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Item ID: D3391-025

Accept

Revision ID:

Item Name: Aft Tube Assembly

Start Date: 8/31/2010 Start Qty: 1.00

Required Date: 9/7/2010 Req'd Qty: 1.00




Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 270  QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| 280  Packaging Packaging | Identify as per dwg & Stock Location: _____ Memo | 0.00 0.00 | | | | | | | |
| 290  QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

SCRAP

ME
10-12-03

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, August 31, 2010 10:45:10 AM

Work Order ID: 61670



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM □□ □□
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6014-090 ALUMINUM EXTRUSION | | Manufactured | No | | | 100 | Each | 29.0000 | 1 | 1 | | | |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> | | | | | | | | | | | | | |
| <div> <div>LG</div> <div>29</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>56572</div> <div>29</div> <div></div> </div> | | | | | | | | | | | | | |
| D3670-4-200 SPACER | | Manufactured | No | | | 230 | Each | 64.0000 | 4 | 4 | | | |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> | | | | | | | | | | | | | |
| <div> <div>LG</div> <div>64</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>57349</div> <div>64</div> <div></div> </div> | | | | | | | | | | | | | |
| D2646 Aft Cap | | Manufactured | No | | | 270 | Each | 71.0000 | 1 | 1 | | | |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> | | | | | | | | | | | | | |
| <div> <div>FP-4</div> <div>62</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>57332</div> <div>62</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>FP6</div> <div>9</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>52663</div> <div>9</div> <div></div> </div> | | | | | | | | | | | | | |

B 56522 08-09-10

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 61670



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 270 Each 8.0000 1 1



Wearpad



Location Loc Qty Loc Code

| | | |
|-------|---|--|
| FP | 1 | |
| 55465 | 1 | |
| FP17 | 7 | |
| 57713 | 3 | |
| 60491 | 4 | |

D3537-7 Manufactured No 270 Each 17.0000 1 1



Wearpad



Location Loc Qty Loc Code

| | | |
|-------|----|--|
| FP | 7 | |
| 46346 | 7 | |
| FP16 | 10 | |
| 56831 | 10 | |

D3553-1 Manufactured No 270 Each 43.0000 1 1



Gasket



Location Loc Qty Loc Code

| | | |
|-------|----|--|
| FP | 43 | |
| 33868 | 1 | |
| 56568 | 42 | |

D3553-3 Manufactured No 270 Each 47.0000 1 1



Gasket



Location Loc Qty Loc Code

| | | |
|-------|----|--|
| FP | 47 | |
| 53480 | 47 | |

Tuesday, August 31, 2010 10:45:10 AM

Shop Packet Print

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 31, 2010 10:45:10 AM

Page 3

Work Order ID: 61670

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each

917.0000 2 2



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

917

42329

150

52505

767

ALS4-1032-130 Purchased No

260 Each

3,094.000 14 14



Insert

Location

Loc Qty

Loc Code

PKG11

2902

114723

2902

ST282

153

110511

10

114407

143

ST381

39

114654

39

ALS4-1032-225 Purchased No

270 Each

5,418.000 12 12



Insert

Location

Loc Qty

Loc Code

PK011

5418

110768

5418

Tuesday, August 31, 2010 10:45:10 AM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 31, 2010 10:45:10 AM

Page 4

Work Order ID: 61670



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

1,567.000

6

6



BOLT

Location

Loc Qty

Loc Code

ST303

500

115438

500

ST350

1067

114108

14

114416

12

114523

2

114941

39

115300

1000

AN3C5A

Purchased

No

270

Each

1,072.000

4

4



Bolt

Location

Loc Qty

Loc Code

ST350

1062

114330

11

115015

251

115108

300

115316

300

115371

100

115422

100

ST351

10

113121

10

Tuesday, August 31, 2010 10:45:10 AM

Shop Packet Print

Page 4

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 31, 2010 10:45:10 AM

Page 5

Work Order ID: 61670



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased

No

270

Each

155.0000

10

10



washer

Location

Loc Qty

Loc Code

ST245

155

107534

29

109545

54

111548

72

Tuesday, August 31, 2010 10:45:10 AM

Shop Packet Print

Page 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|--|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: B61570 |
| Description: Float Skidtube (412) | | Part Number: D3391-3 |
| Inspection Dwg: D3391 | Rev: H | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

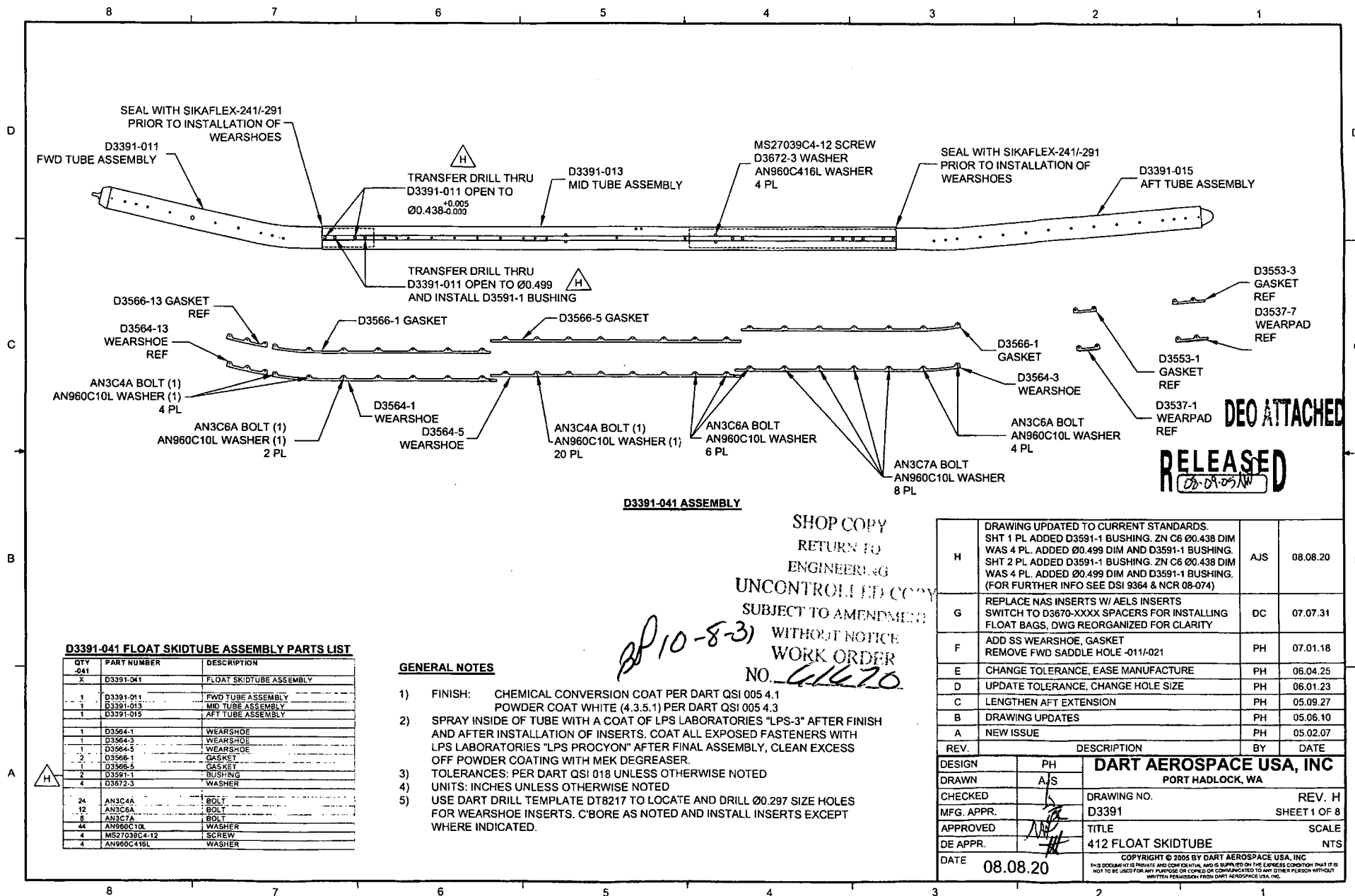
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------------------|-----------|------------------|--------|--------|----------------------|----------|
| Lathe Section | | | | | | |
| 14.000 | +/-0.010 | 14.000 | / | | vern 9.504 | |
| 3.500 | +/-0.010 | 3.495 | / | | | |
| 88.93 | +/-0.030 | 88.940 | / | | | |
| 44.995 | +/-0.030 | 45.000 | / | | | |
| Ø3.200 | +/-0.010 | 3.207 | / | | | |
| 88.93 | +/-0.030 | 88.940 | / | | | |
| Ø3.750 | +/-0.010 | Ø3.750 | / | | | |
| 30° x 160" chamfer | +/-0.010 | 30° x 160" | / | | | |

| | |
|------------------------|-----------------------|
| Measured by: SA | Date: 10-09-08 |
| Audited by: SA | Date: 10/11/16 |

| | | | | | | |
|--------------|---------------|-------|---|--|--|--|
| HAAS Section | | | | | | |
| 1.526 | +0.000/-0.030 | | | | | |
| 7.500 | +/-0.010 | | | | | |
| 27.750 | +/-0.010 | | | | | |
| 31.750 | +/-0.010 | | | | | |
| 35.250 | +/-0.010 | | | | | |
| 3.300 | +/-0.010 | | | | | |
| 0.200 | +/-0.010 | | | | | |
| 3.520 | +/-0.010 | | | | | |
| 0.687 | +0.010/-0.000 | 0.670 | / | | | |
| R0.062 | +/-0.010 | 0.062 | / | | | |
| Ø0.484 | +0.005/-0.001 | | | | | |

| | |
|------------------------|-----------------------|
| Measured by: SA | Date: 10/11/16 |
| Audited by: SA | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | 06.04.24 | New Issue P/O D3391-015/-025 | KJ/JLM | |
| B | 06.06.19 | Dwg revision update | KJ/JLM | |
| C | 07.04.20 | Ø0.208 dimension removed | KJ/JLM | |
| D | 07.09.06 | 0.400 dimension removed | KJ/JLM | |
| E | 07.11.23 | Dwg Rev. updated | KJ/EC/DD | |
| F | 09.04.27 | Dimensions updated per Rev H and NCR09-028 | KJ/JLM | |
| G | 09.11.16 | Dimension 0.200 removed | KJ | |



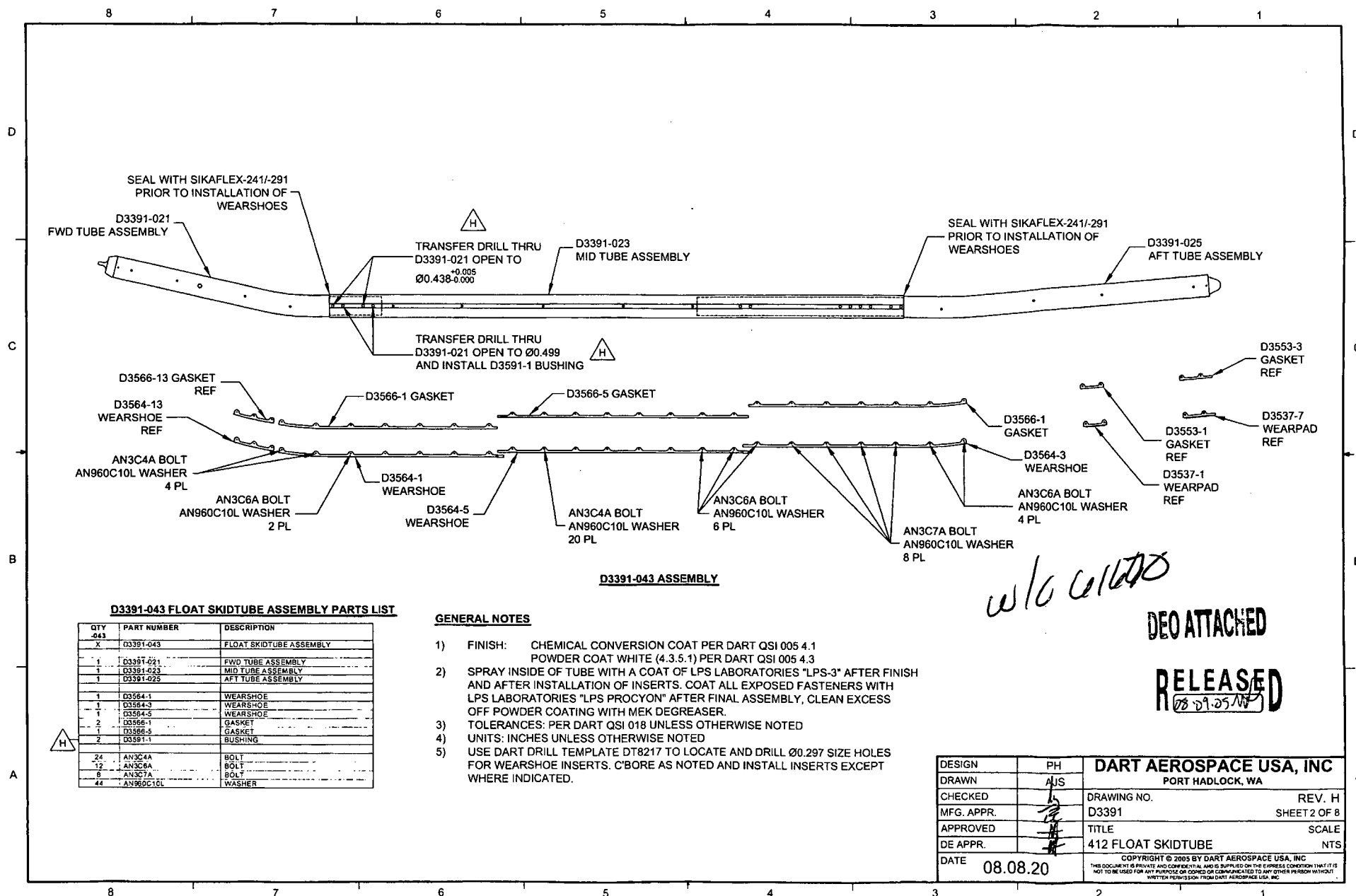
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



Dart Aerospace Ltd

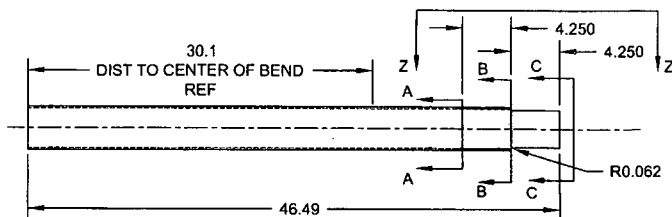
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

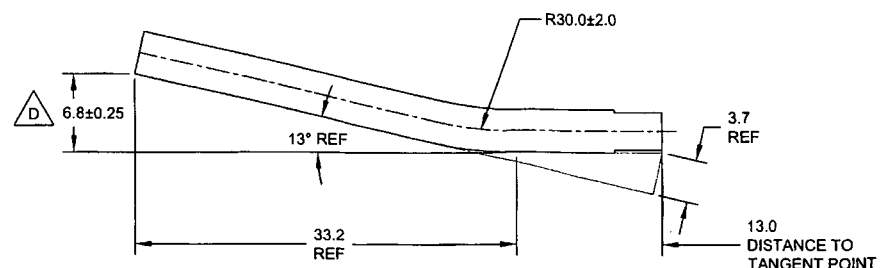
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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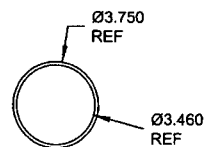
NOTE: Date & initial all entries



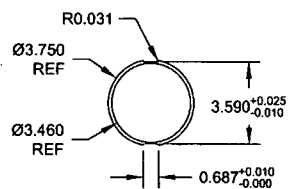
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



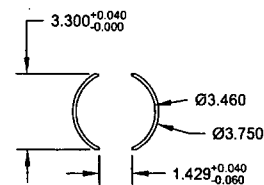
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



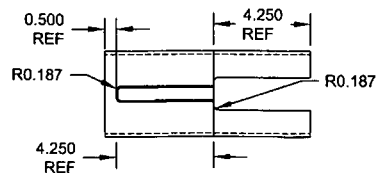
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

w/061670

DEO ATTACHED
RELEASED
28-05-11

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|------------|--------------------|--|--------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | AUS | PORT HADLOCK, WA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D3391 | REV. H |
| MFG. APPR. | <i>[Signature]</i> | SHEET 3 OF 8 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 412 FLOAT SKIDTUBE | NTS |
| DATE | 08.08.20 | <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

Dart Aerospace Ltd

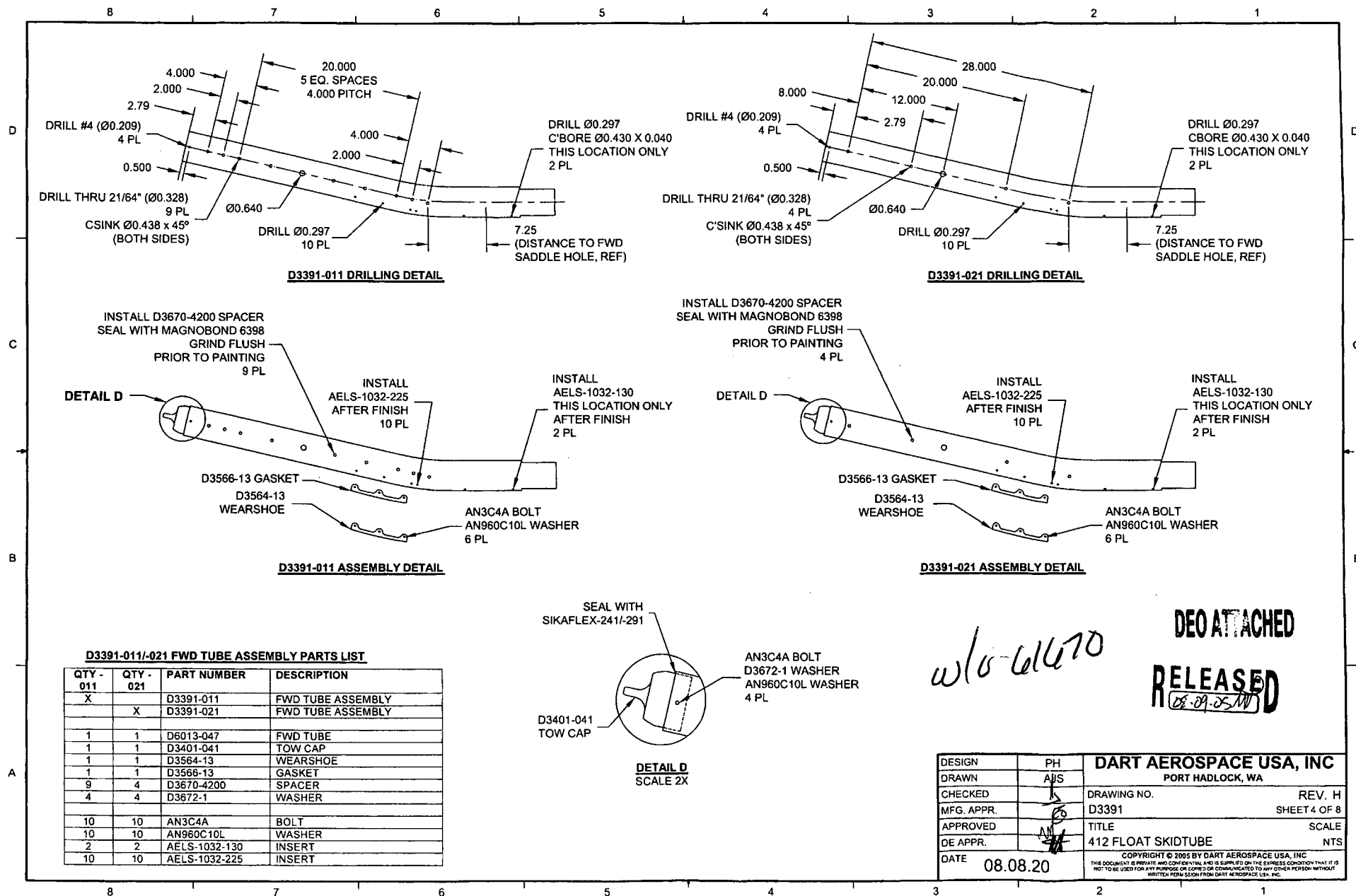
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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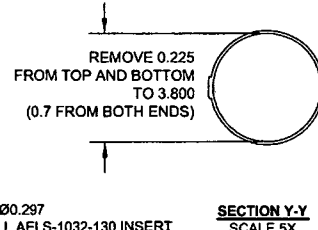
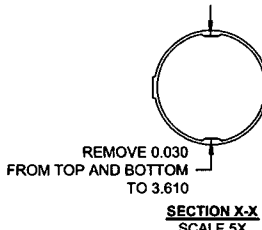
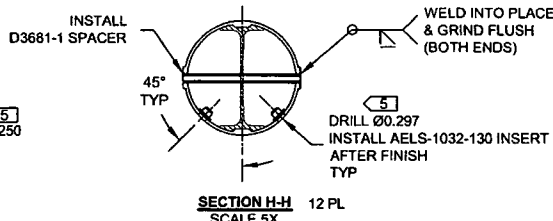
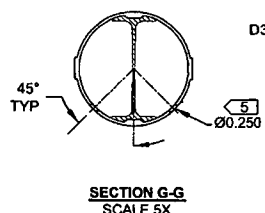
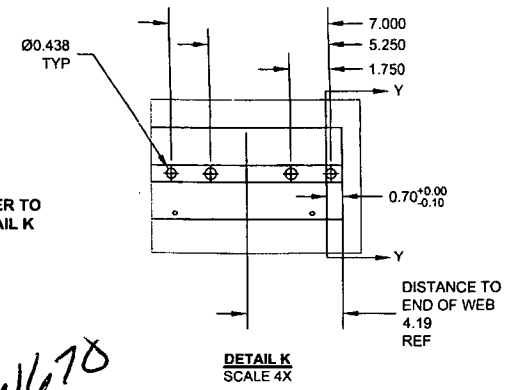
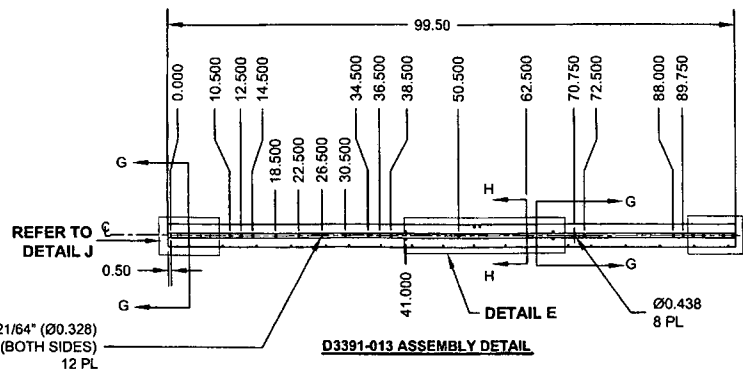
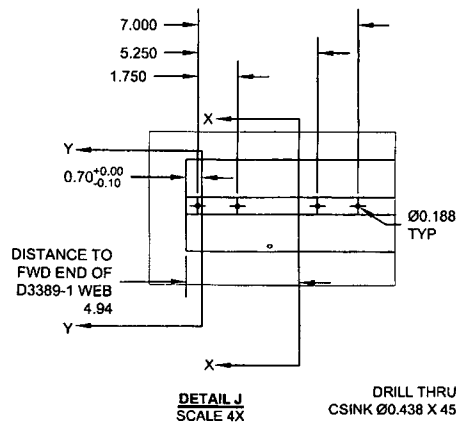
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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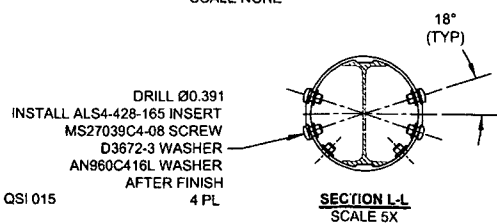
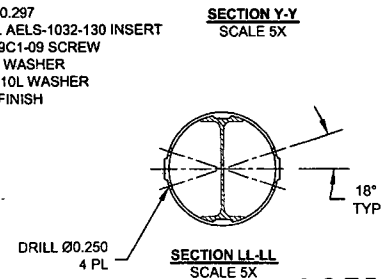
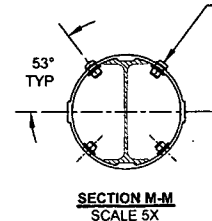
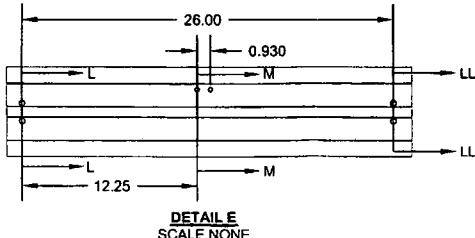
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3391-013 MID TUBE ASSEMBLY PARTS LIST

| QTY -013 | PART NUMBER | DESCRIPTION |
|----------|---------------|-------------------|
| X | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 4 | D3672-1 | WASHER |
| 4 | D3672-3 | WASHER |
| 12 | D3681-1 | SPACER |
| 24 | AELS-1032-130 | INSERT |
| 4 | ALS4-428-165 | INSERT |
| 4 | AN960C10L | WASHER |
| 4 | AN960C416L | WASHER |
| 4 | MS27039C1-09 | SCREW |
| 4 | MS27039C4-08 | SCREW |



D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DEO ATTACHED RELEASED

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| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | AUS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. H |
| MFG. APPR. | | D3391 | SHEET 5 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 412 FLOAT SKIDTUBE | NTS |
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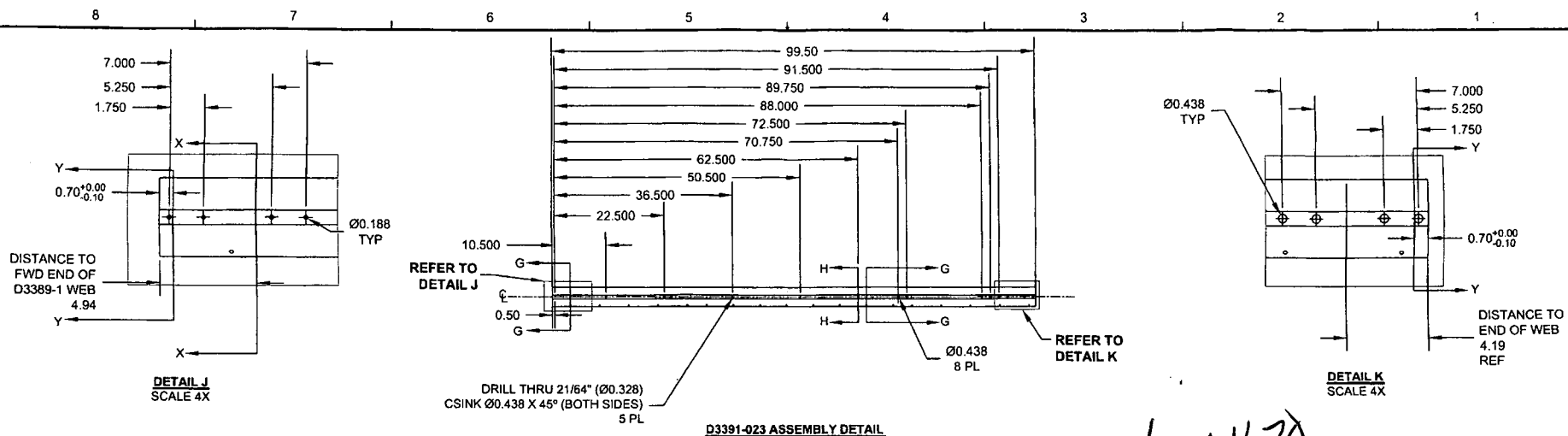
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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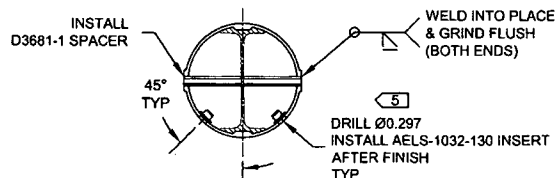
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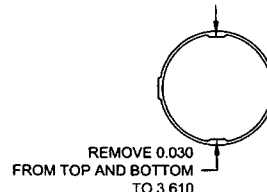
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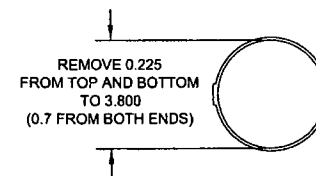
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SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

| QTY - | PART NUMBER | DESCRIPTION |
|-------|---------------|-------------------|
| 023 | | |
| X | D3391-023 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 5 | D3681-1 | SPACER |
| 20 | AELS-1032-130 | INSERT |

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DEO ATTACHED

RELEASED
08 09 05 JV

| | | | |
|---|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. H |
| MFG. APPR. | | D3391 | SHEET 6 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 412 FLOAT SKIDTUBE | NTS |
| DATE | 08.08.20 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

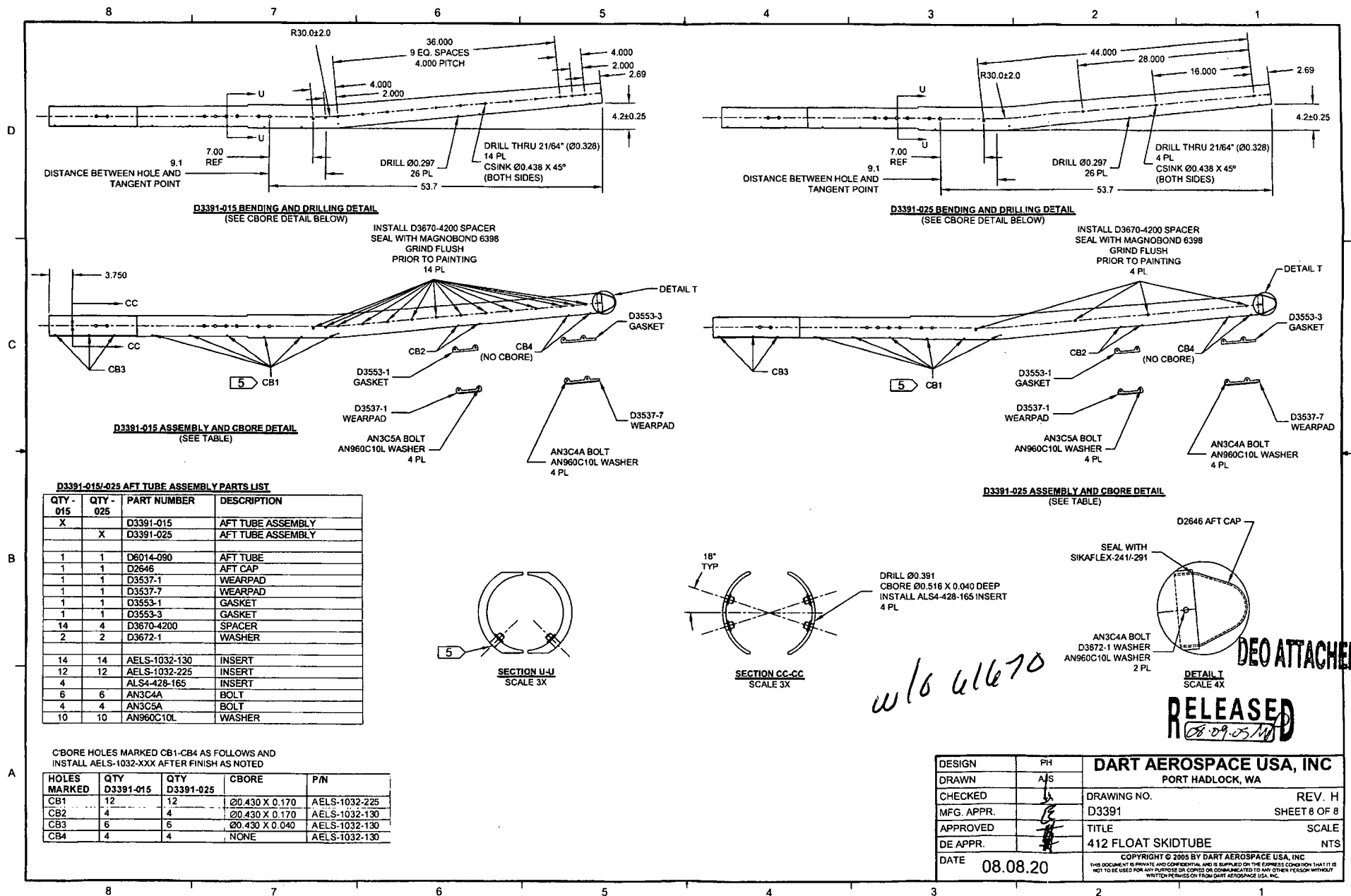
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|----------------------|-----------------------------|-------------------------|--|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3391 | TITLE 412 FLOAT SKIDTUBE | REV. H | DART AEROSPACE USA, INC ENGINEERING ORDER | | D.E.O. NO. D3391-H-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>UP</i> | CHECKED <i>h</i> | MFG. APPR. <i>AA</i> | APPROVED <i>MP</i> | | DE APPR. <i>h</i> | | |
| DATE 09.09.23 | DATE 09.09.24 | DATE 09/09/25 | DATE 09/09/30 | | DATE 09/09/30 | | |

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

w/o 66670

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries